

Date: Saturday, 11/19/2005 10:57:26 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)	
Job Number	: 24825C		Part Number	: D2221	
Estimate Number	: 10189		Drawing Number	: D2221 REV F	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/19/2005 S.O. No. : N/A		Drawing Revision	: F	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A Type : LARGE FAB ASSY		Due Date	: 12/15/2005 Qty: 1 Um: Each	
Previous Run	: 24824C				
Written By	<u>See comment below</u>				
Checked & Approved By	<u>See comment below</u>				
Comment	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		4 D3166-1 RIB <u>B245880</u>	
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2232-3 Hinge bracket <u>B24527</u>	
3.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		4 D2325 Support Gusset <u>B24529</u>	
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2327-3 Bushing <u>B24530</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :	
5.0	D2581	Mounting Bracket	
			<i>11/06/01/10</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2581 Mounting Bracket <u>B23584</u>	<i>11/06/01/10</i>
6.0	D34421	Shim	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D3442-1 Shim <u>B23544</u>	<i>11/06/01/10</i>
7.0	M304EX07516F	Expanded Metal Flat Stai	
		Comment: Qty.: 37.8000 sf(s)/Unit Total : 37.8000 sf(s)	
		Pick:	
		Qty Part Number Description Batch	
		36 sf M304EX0.75-16F Expanded Metal <u>M 19149</u>	<i>11/06/01/10</i>
8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)	
		Pick:	
		28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing	
		Batch: <u>m 19447</u>	<i>11/06/01/10</i>
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235	
		2-Drill hole in D2221-3 as per Dwg D2221	
		3-Deburr	<i>11/06/01/12</i>
		4-Remove all markings on material before welding	
		5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/16
 QA: N/C Closed: _____ Date: _____

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Description :

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06.01.12

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

E 06.01.12

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

IN 06.01.12

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M19134
Expiry date: 06-20-06

FF 06-01-13

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21 54C 06/01/16 (1) (1) GP 06/01/16

Job Completion



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